



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

URGENT

D4275-1
Job Sheet 174738



Part No: D4275-1

Job Qty: 6 ea

Part Name: Fwd Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/18

Job Tracking No:

Due Date: 3/23/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B 10.12.02 AS PER DWG
REV.A DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	3/22/18	3/22/18	0.00	0.00	Start Up Machining-2		<i>DAS 18/03/27</i>
100	Bandsaw	6 pcs	3/22/18	3/22/18	0.00	0.63	Bandsaw1		<i>52 18/03/27</i>
110	CNC Vertical Machining	6 pcs	3/22/18	3/22/18	0.71	11.11	HAAS1-4		<i>89 18/03/27</i>
120	QC	6 pcs	3/22/18	3/22/18	0.00	0.00	QC2 Machining-2		<i>18/03/27</i>
130	QC	6 pcs	3/22/18	3/22/18	0.00	0.00	QC8 Machining-2		<i>18-05-28</i>
140	HandFinish	6 pcs	3/22/18	3/22/18	0.00	0.90	HandFinish1		<i>SA 18-03-28</i>
145	Powdercoat	6 pcs	3/23/18	3/23/18	0.00	0.76	Powdercoat1		<i>BR 18-03-08</i>
150	QC	6 pcs	3/23/18	3/23/18	0.00	0.00	QC3		<i>38 DAS</i>
180	Packaging	6 pcs	3/23/18	3/23/18	0.00	0.00	Packaging3-2	<i>57469</i>	<i>MAR 28 2018</i>
190	QC21-SA	6 Ea	3/23/18	3/23/18	0.00	0.00	QC21		<i>DAS 21 9-20</i>

Part Op 100 - Cut Blank to 39.750" Batch:

Descriptions: 110 - 1-Machine per folio FB006 2- deburr rough edges

145 - MASK AS PER DWG

MAR 28 2018

M 138760 START: 11:30 O.V.T. 5:00 FINISH: 12:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	19.8750 ft (3.3125 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X04.000	20	44	0

Part Specifications

Specifications could not be found.

Plex 3/21/18 8:11 AM dart.lacelle.linda

*5083407 x2 -> 6.625 -> 5055101
5021853 x3 -> 9.938 -> 5055102
5041202 x1 -> 3.313 -> 5055103*



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CANADA
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Container No: S055104



Part: D4275-1

Job No: 174738

Serial No/Batch: S055104

Revision:

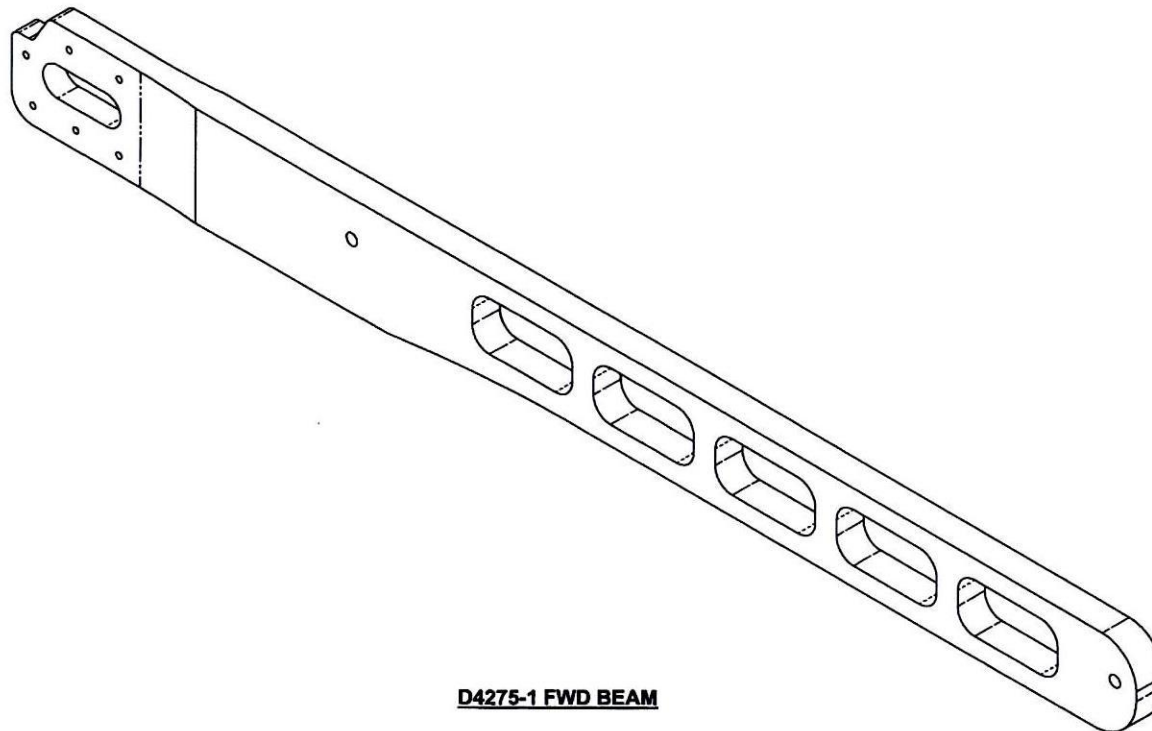
Inspector:

Date: 03/27/18

DART AEROSPACE LTD		Work Order: 174738
Description: Fwd Beam		Part Number: D4275-1
Inspection Dwg: D4275 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.75	✓		Ver.	
26.700	+/-0.010	26.700	↓		TAPE	
Ø0.381	+0.000/-0.001	0.380	↓		G.P.	
8.280	+/-0.010	8.280			TAPE	
1.44	+/-0.030	1.44			Ver	
0.95	+/-0.030	0.950			↓	
3.50	+/-0.030	3.50			↓	
13.28	+/-0.030	13.28			TAPE	
13.50	+/-0.030	13.50			TAPE	
9.25	+/-0.030	9.25			TAPE	
5.00	+/-0.030	5.00			Ver	
0.75	+/-0.030	0.75			↓	
2.75	+/-0.030	2.75				
3.00	+/-0.030	3.002				
1.250	+/-0.010	1.250				
4.50	+/-0.030	4.50				
0.734	+/-0.010	0.734				
0.108	+/-0.010	0.108				
39.48	+/-0.030	39.48				
0.95	+/-0.030	0.951				
0.60	+/-0.030	0.601				
1.750	+/-0.010	1.748				
2.700	+/-0.010	2.695				
1.10	+/-0.030	1.102				
1.25	+/-0.030	1.251				
0.900	+/-0.010	0.899				
0.75	+/-0.030	0.748				
0.250	+/-0.010	0.249				
3.000	+/-0.010	3.002				
1.500	+/-0.010	1.501				
Ø0.191	+0.005/-0.001	0.194			G.P.	



D4275-1 FWD BEAM

210 174739

RELEASED
2010-11-30

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.29 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. A
CHECKED		D4275	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		FWD BEAM	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.11.25	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

